

Work Order ID 118904

June-12-14 10:03:38 AM

\*118904\*

Page 1

Item ID: D4634-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd, Center Ceiling Panel

Start Date: 6/09/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 6/09/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4634	F

100 0.00

\*100\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

①

14/05/15

DAS  
07  
9-89

105

0.00

\*105\*

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 245 deg. F

Time IN: 5:00 PM May 15 2014

Time OUT: 6:00 AM

①

14/05/15

DAS  
07  
9-89



# Work Order ID 118904

June-12-14 10:03:38 AM

**\*118904\***

Page 3

Item ID: D4634-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd, Center Ceiling Panel

Stop **\*NS2\***

Start Date: 6/09/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 6/09/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

0.00

**\*160\***

Packaging

Packaging

Memo

0.00

Packaging

① SWS 14/06/18

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

MLS 14-06-19

① 14-6-19

LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
MLEXS.093-F6006-07	118904	-18	m128668	5/15/14 1:33:34 PM	\$5.98

**DAS**  
**07**  
**9-89**

# Work Order Summary

June-12-14 10:04:41 AM

Page 1 of 1

Criteria : Work Order ID: 118904 Item ID: D4634-1 Product Family THERMOFORMING  
Work Order Start Dates 6/09/14 to 6/09/14 11:59:59 PM Work Order Required Dates 6/09/14 to 6/09/14  
11:59:59 PM

All References

Work Order Status Released

Work Order ID	118904	Required Qty	1.0000	Status Code	Released
Item ID	D4634-1	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Fwd, Center Ceiling Panel				
Current Acct Value	\$507.886				


Start Date	6/09/14	Required Date	6/09/14	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$107.554	\$0.000	\$107.708	\$107.708	100.00%
Labor	\$153.139	\$0.000	\$165.319	\$165.319	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$367.534	\$0.000	\$396.767	\$396.767	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$628.226	\$0.000	\$669.794	\$669.794	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
MLEXS.093-F6006-07					
GE PLASTICS LEXAN SHEET (Grey)	18.0000		5/15/14	18.0000	\$107.554
				Total Matl Amts:	\$107.554

## Work Center Thermoform

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BURY01												
	6/11/14											
130			0.00	0.00	4.25	4.25	1.00	\$0.000	\$121.077	\$290.584	\$0.000	\$411.66
LEGE01												
	5/15/14											
110			0.00	0.00	3.75	0.38	10.00	\$0.000	\$10.688	\$25.650	\$0.000	\$36.33
100			0.00	0.00	1.25	0.13	10.00	\$0.000	\$3.563	\$8.550	\$0.000	\$12.11
	6/10/14											
110			0.00	0.00	2.00	0.50	4.00	\$0.000	\$14.250	\$34.200	\$0.000	\$48.45
100			0.00	0.00	0.50	0.13	4.00	\$0.000	\$3.563	\$8.550	\$0.000	\$12.11
Total:			0.00	0.00	11.75	5.37	29.00	\$0.000	\$153.139	\$367.534	\$0.000	\$520.67

# INSPECTION SHEET

<b>Measured by:</b>  <b>Date</b> 14/06/18	<b>Checked By:</b> DAS 16 9-89 <b>Date</b> 14/06/18	<b>QC inspector:</b> DAS 16 9-89 <b>Date</b> 14/06/18	<b>Engineering Approval (if necessary):</b>  <b>Date</b>
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